



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

ASAP

D3204-3
Job Sheet 180930



Part No: D3204-3

Job Qty: 10 ea

Part Name: Arm



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/18/18

Job Tracking No:

Due Date: ~~7/20/18~~ 8/15

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		7/20/18	0.00	0.00	Start Up Machining-2		Marie Lajeunesse 8/15/18
100	Bandsaw	10 pcs		7/20/18	0.00	0.03	Bandsaw1		" "
110	CNC Vertical Machining	10 pcs		7/20/18	0.33	2.99	HAAS1-3		" "
130	QC	10 pcs		7/20/18	0.00	0.00	QC8 Machining-2		Marie Lajeunesse 8/15/18
140	Packaging	10 pcs		7/20/18	0.00	0.00	Packaging3-1		EL
150	QC21-SA	10 Ea		7/20/18	0.00	0.00	QC21		

Part Op 100 - Cut blank: 2.00" x 0.50" x 6.520" long Bar (+0.030/-0.000)

Descriptions: 110 - 1- Machine as per Folio FA344 and Dwg D3204 Identify as D3204-3

140 - LOCATION : WA002

DAS
21
9-26
AUG 02 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X02.000	6061-T6 Bar .500 X 2.00	5.5380 ft (.5538 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.500X02.000	6	21	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm	6.000Inches ± 0.030	6.030 5.970		
2	Arm	5.250Inches ± 0.030	5.280 5.220		
3	Arm	0.776Inches ± 0.010	0.786 0.766		
4	Arm	0.760Inches + 0.005 - 0.000	0.765 0.760	Diameter	
5	Arm	0.080Inches ± 0.010	0.090 0.070		
6	Arm	0.500Inches ± 0.010	0.510 0.490	Radius	
7	Arm	2.373Inches ± 0.010	2.383		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

			2.363	
8	Arm	0.750Inches ± 0.010	0.760 0.740	
9	Arm	0.380Inches ± 0.010	0.390 0.370	Radius
10	Arm	0.375Inches $+ 0.001$ $- 0.000$	0.376 0.375	Diameter
11	Arm	0.300Inches ± 0.010	0.310 0.290	

Plex 7/18/18 9:20 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL : 1 813 832 - 5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S096127 Part: D3204 - 3 Job No: 180930 Serial No/Batch: S096127 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 07/25/18				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval													
				<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="2" style="text-align: left;">Root Cause</th> </tr> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verificati ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>				Root Cause		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verificati ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%;"> Crimp/Kink/Ripple, ... ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> </tr> </table>				Crimp/Kink/Ripple, ... ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
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